

Date: Monday, 11/05/2009 1:21:09 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SPRING
Job Number : 47852	
Estimate Number : 11161	
P.O. Number :	Part Number : D32601
This Issue : 11/05/2009 S.O. No. :	Drawing Number : D3260 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : PURCHASED PARTS	Drawing Revision : A
Previous Run : 47193	Material :
Written By :	Due Date : 28/05/2009 Qty: 40 Um: Each
Checked & Approved By : <u>Jul 09 05 11</u>	
Comment : Est. A 04.03.29 New issue KJ/RF	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
-----	----	------------

**Comment:** PURCHASINGIssue P/O: 8786C L09/05/12

Make as per Dwg D3260

Possible Supplier: Victory Spring

Material release note is required

(40)

2.0	D32601P	Spring
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)
 Spring

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------

**Comment:** PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage

Ensure Material Release Note is attached

P 8/5/20 (40)

4.0	QC6	DIMENSIONAL CHECK
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**Comment:** DIMENSIONAL CHECKS 9/6/21 (40)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Identify and Stock

Location: 879/5/21(40x)SP

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 11/05/2009 1:21:10 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPRING

Job Number: 47852

Part Number: D32601

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



09/05/26 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mk
09-05-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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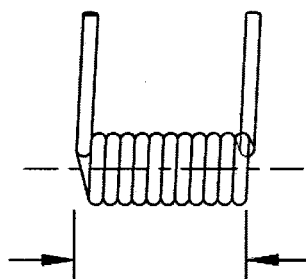
NOTE: Date & initial all entries



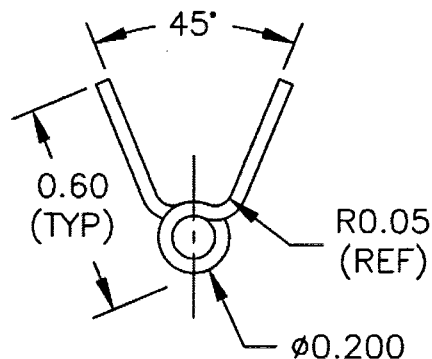
DESIGN JT	DRAWN BY JT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED JT	APPROVED JT	DRAWING NO. D3260	REV. A SHEET 1 OF 1
DATE 04.02.27		TITLE SPRING	SCALE 2:1
A	04.02.27	NEW ISSUE	

RELEASED
04.04.07

SPECIFICATION CONTROL DRAWING



$\phi 0.040$
12 COIL
(REF 0.480)



D3260-1 SPRING

D3260-1 NOTES:

- 1) MATERIAL: AISI 302 SS SPRING WIRE $\phi 0.040$ PER ASTM A313
(MIN TENSILE STRENGTH = 250 ksi)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

SHOP COPY

RETURN TO
ENGINEERING

CONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 47852

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VICTORY SPRING

PACKAGESLIP

19422

convenient. consistent. correct.

#2, 6104 - 82 Ave
Edmonton, AB T6B 0E7
t + 780 442 4020
f + 780 466 8800

BILL TO:

Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury ON K6A 1K7

SHIP TO:

19-May-09	8786	Fedex 151793240
40	D32601P Torsion Spring - Stainless Steel	del-b
854454527	NET 30 DAYS	

CERTIFICATE OF CONFORMANCE

REPORT FOR : Dart Aerospace Ltd.	DATE: 5/19/2009
PART/DRAWING #: D32601P	PO # 8786
SPRING DESCRIPTION: Torsion	QUANTITY: 40

CHARACTERISTIC	SPECIFIED	MEASURED	NOTES
Material type	SS 302	yes	
Material diameter	0.04	0.04	
Coil O.D.	0.200	0.199	
Number of Coils	12	12	
Free Length	.480 ref	0.477	
Helix	LHW	yes	
End type	legs as per dwg.	yes	

COMMENTS

Mill Certificate attached:
Material Heat Number:

Inspected by: *Jeremy Burrows*



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Edmonton, AB T6B 0E7
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f + 780 466 8000

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REPORT FOR : Dart Aerospace Ltd.	DATE: 5/19/2009
PART/DRAWING #: D32601P	PO # 8786
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